

NCR-19-7426



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5505-1

Job Sheet 196675



Part No: D5505-1

Job Qty: 3 pcs

Part Name: Base, Upper Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/16/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D5505 Rev.A10 IPP REV:A 17.11.13 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Purchasing	3 pcs	7/16/19		0.00	0.00	Purchasing - 1		JUL 11 2019
							Purchasing - 2		
							Purchasing - 3		
96	Packaging 2-1 - Receive - B4B	3 pcs	7/16/19		0.00	0.00	Packaging 2 - 1 - B4B		JUL 11 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S197502



Part: D5505-1

Job No: 196675

Serial No/Batch: S197502

Revision: A10

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/11/19

Plex 6/18/19 3:27 PM dart.lussier.patrick

P.T.O.

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
97	QC 6	3 pcs	7/16/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
120	Outsource - 4 - Anodize	3 pcs	7/16/19	0.00 0.00	ATG001
130	Packaging 2-1 - Receive - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
140	QC 5	3 pcs	7/16/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49

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JUL 17 2019 9:59

2019-07-15

DP JUL 19 2019

				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	81
				QC 5 - 40	9-89
					JUL 19 2019
170 Packaging 3-1 - Stock - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	02 Bin: CCK123
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	3 pcs	7/16/19	0.00 0.00	QC 21 - SA - 21	→ Bin: CCK123
				QC 21 - SA - 70	JUL 26 2019
				QC 21 - SA - 53	DAS 70 9-89

Part Op 95 - ISSUE P/O TO WEJAY: HB043770 MACHINE D5505-1 AS PER DWG C OF C IS REQUIRED

Descriptions: 96 - Receive & Inspect for Damage & Mat'l Certs
 97 - QC6- All purchased or subcontracted products
 120 - Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: 44008 HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required
 130 - Receive & Inspect for Damage & Mat'l Certs
 140 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

x3 *hls* June 18, 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5505-1P	Base, Upper Cutter	3 pcs (1 ea)	95-Purchasing	5197501

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-Purchasing	D5505-1P	3	0	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043778



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: POHB043778
PO Date: 6/18/19
Due Date: 7/16/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196673	D5500-1P			Body, Upper Cutter As per Dwg D5500 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$2,436.00/Ea	\$7,308.00
2	196674	D5501-1P			Body, Lower Cutter, Long As per Dwg D5501 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$3,144.00/Ea	\$6,288.00
3	196675	D5505-1P			Base, Upper Cutter : Various STC's As Per Dwg D5505-1 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$1,120.00/Ea	\$3,360.00
4	196676	D5506-3P			Base, Lower Cutter, Long As Per Dwg 5506 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$1,447.00/Ea	\$2,894.00

Grand Total: \$19,850.00

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043778



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "Patrick Lussler".

Plex 6/18/19 3:57 PM dart.lussler.patrick



Packing Slip 39279

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1632 FAX: 613-384-2997
 www.wejay.com

SOLD TO
 Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K7

SHIP TO
 Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO PCH043778		DATE ORDERED 06/18/19		SHIPPED VIA Best way	
CUSTOMER CODE PCH043778		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	S.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
3	0	3	Body, upper cutter as per drawing D5500, Rev. A Part No. D5500-1P				
2	0	2	Body, lower cutter, long as per drawing D5501, Rev. A Part No. D5501-1P				
3	0	3	Base, upper cutter, various SPC as per drawing D5505-1, Rev. A Part No. D5505-1P				
2	0	2	Base, lower cutter as per drawing D5506-3, Rev. A Part No. D5506-3P				

RECEIVED
 JUL 11 2019
 DART AEROSPACE LTD.

Required by: July 16, 2019

RELEASE NOTE

I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.

Inspection Supervisor [Signature] WMP 03

July 10/19

H.S.T.

ORDER: COMPLETE ☐ PARTIAL ☐

TOTAL

RECEIVED BY: _____
 .5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace

DATE: July 4, 2019

P.O.# POHB043778 item 3

WEJAY JOB# 39579

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D5505-1P 'Base, Upper Cutter' JOB#196675	3	Machined complete per drawing req'ts.	D5505-1 / rev. A
Note: 1) Material: . Material Test Cert. attached - ref. 'Constellium' Lot# 9440809 (Wejay TN# 35073-2) 2) 1st Article Inspection / Test Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

DAS
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Clifford Smith
Authorized Q.A. Signatory



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

SHIP
TO

THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

SOLD
TO

COPPER & BRASS SALES

PO BOX 5116
SOUTHFIELD MI
48066
US

COPPER&BR		110730252		4075		INCLUSION		Serial:20190201-0110730252		Pg 1of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424185-R01						Constellium ORDER NO. 264541					
ALLOY 7075	CLAD	TEMPER T651	GAUGE 2.03000 in 51.56 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm	CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunberger - Laboratory Manager					
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS QQ-A-250/12A											
PART NUMBER ALFLR00999			B/L NUMBER 112678		DATE SHIPPED 02/01/2019						
WT. SHIPPED 5580.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.							

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

AMS 4045L
ASTM B209-14
Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001965365	1,860.000	843.681	9440809	01		
1001965365	1,860.000	843.681	9440809	02		
1001965366	1,860.000	843.681	9440809	03		

Lot: 9440809 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	81.2	81.5	72.3	72.6	13.5	13.5	

Tensile - Room Temperature (SI)

		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	562	562	498	501	13.5	13.5	

REF. DAET PO# POHBD43778 ITEMS 1, 2 & 3
ITEM 1 - BODY, UPPER CUTTER - PART# D5500-1P
ITEM 2 - BODY, LOWER CUTTER - PART# D5501-1P
ITEM 3 - BASE, UPPER CUTTER - PART# D5505-1P

TN35073-1E2
Job# 39579
rec'd June 24/19

P-850-155D REVISED: 01 2018

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD

CstAr

Wgt.: 405.671 LB

Del.: 2406829911

CstOr 35073

Date 06/21/2019

WMP
03 JUN 21/19





THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

COPPER & BRASS SALES

PO BOX 5116
SOUTHFIELD MI
48086
US

COPPER&BR		110730252		4075		INCLUSION		Serial:20190201-0110730252		Pg 2of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424185-R01						Constellum ORDER NO. 264541			CERTIFICATION "Constellum Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellum Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellum Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 88 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager		
ALLOY 7075	CLAD	TEMPER T651	GAUGE 2.03000 in 51.56 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm						
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS QQ-A-250/12A											
PART NUMBER ALFLR00999				B/L NUMBER 112678		DATE SHIPPED 02/01/2019					
WT. SHIPPED 5580.000 LB			NO. OF PIECES 000003		GOVT. CONTRACT NO.						
Chemistry (Actual)											
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR		
Core	0.07	0.19	1.42	0.04	2.47	0.19	5.70	0.03	0.01		
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER											
All material contained in this lot was cast and manufactured in the USA											
QUALITY TEXTS: Constellum Rolled Products Ravenswood, LLC (Constellum) certifies that all metals and materials supplied are in compliance with European Union Directives 2002/95/EC and 2011/65/EU. Constellum further certifies that a copy of these directives, which provides restrictions on the use of certain hazardous substances (RoHS) in electrical and electronic equipment, have been received and read in their entirety. Constellum understand and agrees, as a supplier that it is responsible for meeting the requirements of RoHS and RoHS2 directives.											
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557 DUNS Number: 090570149; CAGE Code: 1YW19 Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"											
P-860-155D REVISED: 01 2018											

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD Del.: 2406829911

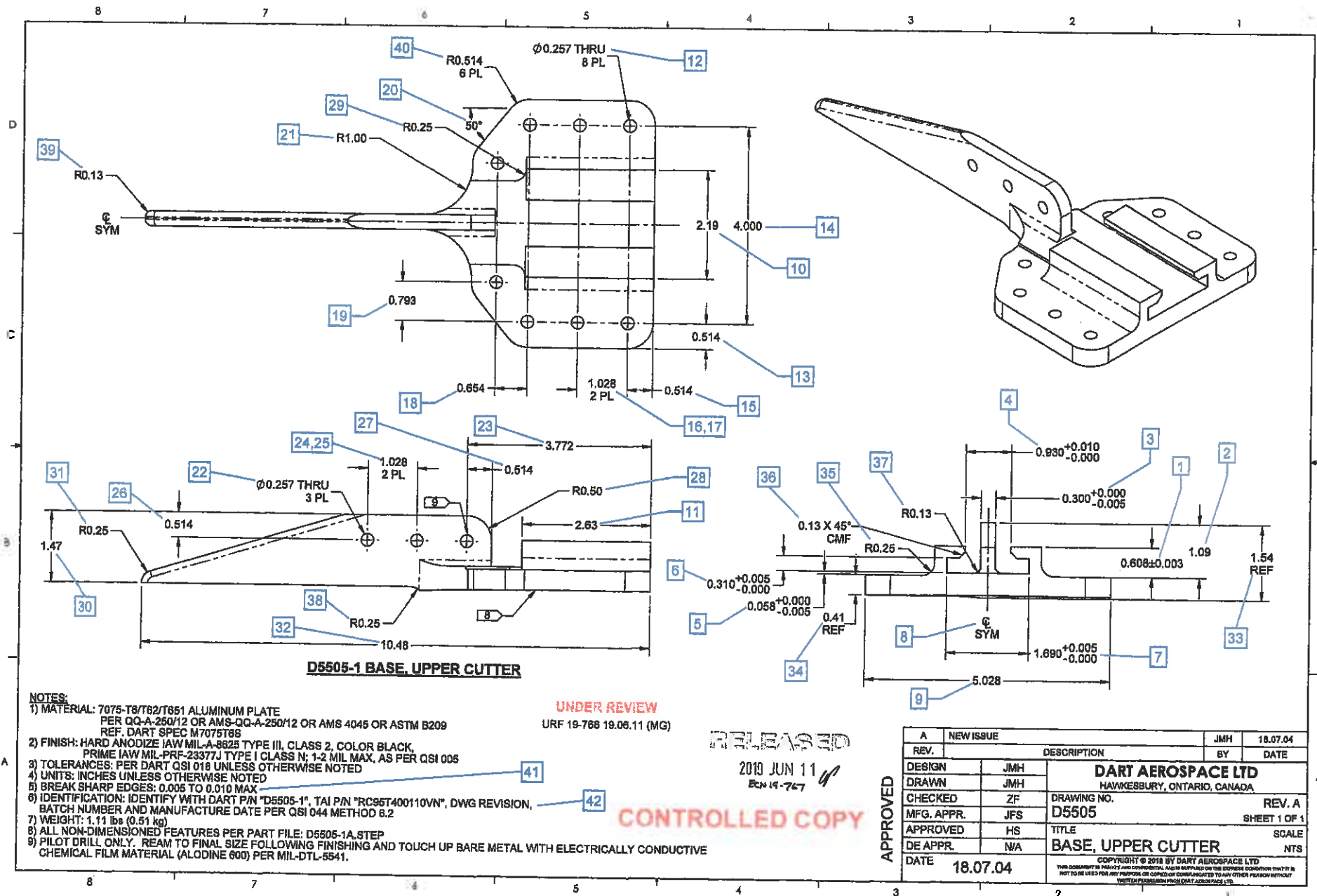
CstAr

CstOr 35073

Wgt. : 405.671 LB

Date 06/21/2019

Thomas Sanchez





Customer DART Aerospace Customer P.O. PO#B043778 ITEM 3
Drawing # D5505-1 Drawing rev A
Part Number D5505-1P E.C.O.
Part Name Base, Upper Cutter Material Alum. Plate 7075-T651
Serial # 39579-3-001 Inspected by Cliff Smith
Job # 39579 Signature: WMP 03 ACCEPTED



Overall Result

All Characteristics: 65
Out of tolerance: 0
Over Warning Limit: 0
Not Calculated: 0

Comment: Final Dim. Insp.

- 1ST ARTICLE -

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-->
1a 1_B2	Z	0.6080	0.6080	0.0030	-0.0030	0.0000	└┐
1b 1_B2	Z	0.6079	0.6080	0.0030	-0.0030	-0.0001	└┐
2 1_B1	Z	1.0898	1.0900	0.0300	-0.0300	-0.0002	└┐
3 1_B2	CartDist	0.2989	0.3000	0.0000	-0.0050	-0.0011	└┐
Parallelism rel .300 dim	GDT Par	0.0012	0.0000	0.0025		0.0012	└┐
4 1_C21	CartDist	0.9309	0.9300	0.0100	0.0000	0.0009	└┐
5 1_B4	Z	0.0562	0.0580	0.0000	-0.0050	-0.0018	└┐
6a 1_B4	CartDist	0.3119	0.3100	0.0050	0.0000	0.0019	└┐
6b 1_B4	CartDist	0.3123	0.3100	0.0050	0.0000	0.0023	└┐
7t 1_B4	CartDist	1.6905	1.6900	0.0050	0.0000	0.0005	└┐
7c 1_B2	CartDist	1.6909	1.6900	0.0050	0.0000	0.0009	└┐
7b 1_B3	CartDist	1.6911	1.6900	0.0050	0.0000	0.0011	└┐
8a 1_B2	GDT Sym	0.0013	0.0000	0.0050		0.0013	└┐
8b 1_B2	GDT Sym	0.0022	0.0000	0.0050		0.0022	└┐
9 1_A2	CartDist	5.0267	5.0280	0.0100	-0.0100	-0.0013	└┐
10 1_D4	CartDist	2.1921	2.1900	0.0100	-0.0100	0.0021	└┐
11a 1_B5	X	-2.6328	-2.6300	0.0100	-0.0100	-0.0028	└┐
11b 1_B5	X	-2.6325	-2.6300	0.0100	-0.0100	-0.0025	└┐
12a 1_D5(1)	D	0.2588	0.2570	0.0060	-0.0010	0.0018	└┐
12a 1_D5(2)	D	0.2589	0.2570	0.0060	-0.0010	0.0019	└┐
12a 1_D5(3)	D	0.2589	0.2570	0.0060	-0.0010	0.0019	└┐
12a 1_D5(4)	D	0.2588	0.2570	0.0060	-0.0010	0.0018	└┐
12a 1_D5(5)	D	0.2589	0.2570	0.0060	-0.0010	0.0019	└┐
12a 1_D5(6)	D	0.2588	0.2570	0.0060	-0.0010	0.0018	└┐
13-17 1_C4(1)	GDT Po2d	0.0014	0.0000	0.0200		0.0014	└┐
	X	-0.5136	-0.5140			0.0004	
	Y	0.5135	0.5140			-0.0005	
13-17 1_C4(2)	GDT Po2d	0.0017	0.0000	0.0200		0.0017	└┐
	X	-1.5416	-1.5420			0.0004	
	Y	0.5132	0.5140			-0.0008	
13-17 1_C4(3)	GDT Po2d	0.0022	0.0000	0.0200		0.0022	└┐
	X	-2.5696	-2.5700			0.0004	
	Y	0.5130	0.5140			-0.0010	



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
13-17 1_C4(4)	GDT Po2d	0.0023	0.0000	0.0200		0.0023	-
	X	-0.5147	-0.5140			-0.0007	
	Y	4.5131	4.5140			-0.0009	
13-17 1_C4(5)	GDT Po2d	0.0027	0.0000	0.0200		0.0027	-
	X	-1.5428	-1.5420			-0.0008	
	Y	4.5129	4.5140			-0.0011	
13-17 1_C4(6)	GDT Po2d	0.0031	0.0000	0.0200		0.0031	-
	X	-2.5707	-2.5700			-0.0007	
	Y	4.5126	4.5140			-0.0014	
12b 1_D5(1)	D	0.2590	0.2570	0.0060	-0.0010	0.0020	-
12b 1_D5(2)	D	0.2588	0.2570	0.0060	-0.0010	0.0018	-
18-19 1_C6(1)	GDT Po2d	0.0024	0.0000	0.0200		0.0024	-
	X	-3.2238	-3.2240			0.0002	
	Y	1.3058	1.3070			-0.0012	
18-19 1_C6(2)	GDT Po2d	0.0031	0.0000	0.0200		0.0031	-
	X	-3.2245	-3.2240			-0.0005	
	Y	3.7195	3.7210			-0.0015	
20a 1_D6	A	50.4972	50.5000	0.5000	-0.5000	-0.0028	-
20b 1_D7	A	50.4859	50.5000	0.5000	-0.5000	-0.0141	-
21 1_D6	R	0.9997	1.0000	0.0300	-0.0300	-0.0003	-
22 -per note 9- 1_B7(1)	D	0.2437	0.2420	0.0060	-0.0010	0.0017	-
22 -per note 9- 1_B7(2)	D	0.2441	0.2420	0.0060	-0.0010	0.0021	-
22 -per note 9- 1_B7(3)	D	0.2437	0.2420	0.0060	-0.0010	0.0017	-
23-26 1_B6(1)	GDT Po2d	0.0127	0.0000	0.0200		0.0127	-
	Z	-0.5202	-0.5140			-0.0062	
	X	-3.7734	-3.7720			-0.0014	
23-26 1_B6(2)	GDT Po2d	0.0132	0.0000	0.0200		0.0132	-
	Z	-0.5204	-0.5140			-0.0064	
	X	-4.8015	-4.8000			-0.0015	
23-26 1_B6(3)	GDT Po2d	0.0124	0.0000	0.0200		0.0124	-
	Z	-0.5201	-0.5140			-0.0061	
	X	-5.8294	-5.8280			-0.0014	
27 1_B5	CartDist	0.5208	0.5220	0.0100	-0.0100	-0.0012	-
28 1_B5	R	0.5060	0.5000	0.0300	-0.0300	0.0060	-
29 1_D6	R	0.2457	0.2500	0.0300	-0.0300	-0.0043	-
30 1_B8	CartDist	1.4612	1.4700	0.0100	-0.0100	-0.0088	-
17 deg angle_e-model	A2	17.0674	17.0000	0.5000	-0.5000	0.0674	-
31 1_B8	R	0.2525	0.2500	0.0300	-0.0300	0.0025	-
32 1_B6	ResEle	10.4839	10.4800	0.0300	-0.0300	0.0039	-
33 1_B1	Z	-1.5388	-1.5400	0.0300	-0.0300	0.0012	-
34 1_B3	Z	-0.4070	-0.4100	0.0100	-0.0100	0.0030	-
Mount Face_Point 1_e-model	Z	-0.4102	-0.4108	0.0100	-0.0100	0.0007	-
Mount Face_Point 2_e-model	Z	-0.4155	-0.4186	0.0100	-0.0100	0.0031	-
Mount Face_Point 3_e-model	Z	-0.3944	-0.3983	0.0100	-0.0100	0.0040	-
Mount Face_Point 4_e-model	Z	-0.3974	-0.4015	0.0100	-0.0100	0.0040	-
Mount Face_Point 5_e-model	Z	-0.3983	-0.4015	0.0100	-0.0100	0.0033	-
Mount Face_Point 6_e-model	Z	-0.4088	-0.4117	0.0100	-0.0100	0.0028	-
Mount Face_Point 7_e-model	Z	-0.4093	-0.4130	0.0100	-0.0100	0.0037	-
Mount Face_Point 8_e-model	Z	-0.4154	-0.4193	0.0100	-0.0100	0.0039	-

Measurement Plan D5505-1 Rev. A_Final Insp		Date July 3, 2019	3				
Part Number D5505-1P	Serial # 39579-3-001	Time 2:59:15 pm					
Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->

Manually Inspected Details

35	1_B4	R0.25					<u>R-250TYP.</u>
36	1_B4	0.13 x 45 chamfer					<u>c127x45°TYP.</u>
37	1_B3	R0.13					<u>R.125TYP.</u>
38	1_B6	R0.25					<u>R.250</u>
39	1_D8	R0.13					<u>R-130</u>
40	1_D6	R0.514 6 pl.					<u>R.514TYP.</u>
41	1_A8	Deburring per note 5					<u>PASSED</u>
42	1_A8	Identification per note 6					<u>PASSED</u>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044008

PO Date: 7/15/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: ***RUSH***

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196015	646.2910	Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed -		7/19/19	16 pcs	0 pcs	16 pcs	\$53.77/pcs	\$860.32
2	196673	D5500-1	Body, Upper Cutter Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed -		7/19/19	3 pcs	0 pcs	3 pcs	\$26.52/pcs	\$79.56
3	196674	D5501-1	Body, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed -		7/19/19	2 pcs	0 pcs	2 pcs	\$26.52/pcs	\$53.04



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196675	D5505-1	Base, Upper Cutter Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	3 pcs	0 pcs	3 pcs	\$24.62/pcs	\$73.86
				X3			JUL 19 2019				DP
							5197502				
5	196676	D5506-3	Base, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	2 pcs	0 pcs	2 pcs	\$24.62/pcs	\$49.24
				X2			5197504				DP
Grand Total:											\$1,116.02

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 8:32 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 3 ea	Part: D5500-1 ✓ Body, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25476 PO: POHB044008 ✓		Rev: A8 Line: 2
✓ 2 ea	Part: D5501-1 ✓ Body, Lower Cutter, Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25477 PO: POHB044008 ✓		Rev: A7 Line: 3
✓ 3 ea	Part: D5505-1 ✓ Base, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25478 PO: POHB044008 ✓		Rev: A Line: 4
✓ 2 ea	Part: D5506-3 ✓ Base, Lower Cutter Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: A <

RECEIVED

JUL 18 2019

DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0006-.0009" (.8 - .9 mils) per drawing. Job: 25479 PO: POHB044008 ✓	Line: 5	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 18 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

Entered: JK Date: OCT 21/19



NCR No. 19-7426

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>196675</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>05505-1</u>		Rework ☒	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☒	
Date: <u>JUL 12 2019</u>	Sequence #: <u>97</u>	QTY Affected: <u>3 of 3</u>			MRB (QSI042)		
Description Work Order Deviation			Disposition				
<u>Ø0,257 holes at 3 places are Ø0,243 which is too small</u>			<u>drill hole at Ø.257</u>				
			Completed By <u>40</u>				
			<u>9-89</u> 12 2019				
			Lead hand / Supervisor <u>mf</u>				
			<u>12/07/26</u>				
			QC / QA Coordinator				
			OCT 11 2019				
			DAS <u>68</u>				
			<u>9-89</u>				
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☒	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☒	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details:						